Qty:

67.05.17

200 Um:

Each

Monday, 4/23/2007 1:48:22 PM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

: BUSHING

: D2652

: N/A

:NA

: 5/10/2007

: A

· D2652 REV A

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 31985

Estimate Number

: 10725

P.O. Number

This Issue

First Issue

Written By

Previous Run

:414:

: 4/23/2007 Prsht Rev.

Checked & Approved By

. NA

: 31298

S.O. No. : 11

Type

: MACHINED PARTS

Comment

: Est Rev:B 02.06.13

Now machined in house.

NG

Description:

Material

Due Date

Additional Product

Job Number:



Seq. #:

2.0

3.0

Machine Or Operation:

303 Round Bar 0.500"

1.0 M303R0500



0.0578 f(s)/Unit Total: 11.5500 f(s)

Comment: Qty.:

Material:303 ss .500" Round Bar

(M303R0500)

Batch: 102444

could not enter!

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

4.0 QC8

Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



4

07.05.17

Page 1

Dart Aerospace Ltd	D	art	Ae	ros	pace	Ltd
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W/O:			WORK ORDER CHANGES								
DATE	DATE STEP		TEP PROCEDURE CHANGE		PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·									
			4								
		4									
		· · · · · · · · · · · · · · · · · · ·				<u> </u>					

Part No: _	PAR #: _	Fault Category:	NCR: Yes No DQA:	Date: <u>07/05/22</u>
			QA: N/C Closed:	Date:

NCR:	R: WORK ORDER NON-CONFORMANCE (NCR)							
		Corrective Action Section B			Verification	Annroyal	Annroyal	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				,				
-								

NOTE: Date & initial all entries

Date:

Monday, 4/23/2007 1:48:22 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Part Number: D2652

Job Number: 31985

Seq. #:

Job Completion

Job Number:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(26/105/22

Dart	Aei	rosi	pace	Ltd
_ ~			~~~	

W/O: WORK ORDER CHANGE										
DATE	STEP		PROCE	EDURE CHANGE	÷	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		4.4								
Part No	:	PAR	#:	Fault Category:	NO	R: Yes	No DQ	4 :	_ Date: _	

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annroval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
		į.						
		·						
	-							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31985
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.600	_			
0.060	+/-0.005	-060				
Ø0.305	-0.002/+0.000	304	_			
Ø0.191	+0.005/-0.000	1197				
Ø0.500	+/-0.010	. 498	_			
0.030 x 20°	+/-0.010	.070	1			
R0.010	+0.010/-0.000	. 610	/			
	2					
				·	·	
						,
		· <u>-</u>				

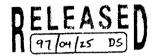
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 67.05.17	Date: 07/05/14	Date:	

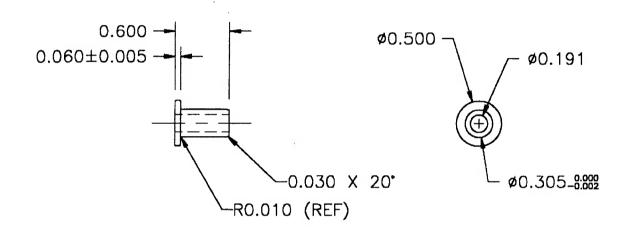
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 4





DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED OI OV	DRAWING NO. D2652	REV. A
DATE	DI UI	TITLE	SHEET 1 OF 1 SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISEUNGONEROLLED COPY SUBJECT TO AMENDMEN

WITHOUT NOTICE

NO. 31985

SHOP COPY

RETURN TO ENGINEERING